

Del 1.00 Work Order ID 68469

Wednesday, April 13, 2011 4:15:55 PM



Page 1

Item ID: D3455-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Spacer					
Start Date: 4/13/2011	Start Qty: 30.00		Cust Item ID:		
Required Date: 4/20/2011	Req'd Qty: 30.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 4-04-13	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3455	Rev A

100	Hardinge CNC LATHE SMALL	0.00				30	0		
	Hardinge	Memo							
Hardinge CNC Lathe Small	HARDINGE COBRA 1-TURN AS PER FOLIO FA583 & DWG D3455 <input type="checkbox"/> FOLIO REV: <u>L</u> <input type="checkbox"/> DWG REV: <u>L</u> <input type="checkbox"/> 2-DEBURR AS REQUIRED 11/5/17								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				30	0		
	QC	Memo							
Quality Control	11/5/17								
120	QC8- Inspect parts - second check	0.00				30	0		
	QC	Memo							
Quality Control	11-5-17								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68469

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Item ID: D3455-1

Accept



Setup Start



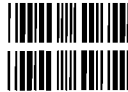
Revision ID:

Item Name: Spacer

Stop



Start Date: 4/13/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

105/17

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Swetics

count
30

7 P16 ->

150

0.00



Identify as per dwg & Stock Location: 54

Packaging

Memo

0.00

Packaging

11/5/19 302

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68469

Wednesday, April 13, 2011 4:15:55 PM



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Item ID: D3455-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 4/13/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/15/19 [Signature]

11-05-19
(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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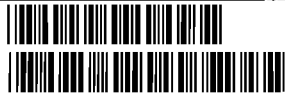
NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 4:16:01 PM

Page 1
T

Work Order ID: 68469



Parent Item: D3455-1

Parent Item Name: Spacer

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.000 Delrin Round Bar 1"		Purchased	No			100	f	4.7680	0.022	0.694737			

SH 4/18/17

Location

Loc Qty

Loc Code

MAT055

4.768

116266

4.768

114586

.5 LF

MDELNR 1.250
JUL 11-05-17
THIS BATCH ONLY!

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



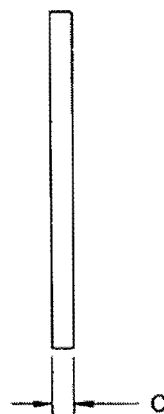
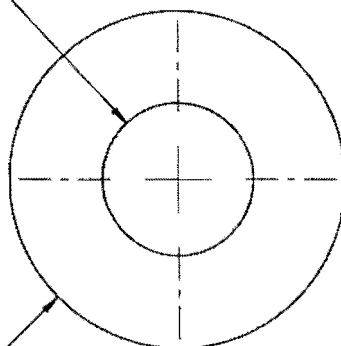
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

RELEASED

05.12.09 *[Signature]*

$\phi A^{+0.005}_{-0.000}$

ϕB



D3455-X

1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

CD 11105117
Q10: 68469

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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